

Date: Thursday, 17/04/2008 2:02:15 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR SLUG
Job Number : 38678	
Estimate Number : 10162	
P.O. Number :	Part Number : D2587
This Issue : 17/04/2008 S.O. No. :	Drawing Number : D2587 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 36044	Material :
Written By :	Due Date : 25/04/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JLD 08-4-17</u>	
Comment : Est D 04.05.31 Step 2 changed KJ/JLM Est E 06.07.31 Waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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17



Comment: Qty.: 0.0168 sf(s)/Unit Total: 0.3360 sf(s)
 6061T6 alum. sheet 0.040" thick
 Batch: 100742 18 8-4-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2587
 Dwg Rev: A1
 Prog Rev: A1

18 8-4-18

2-Deburr if necessary

RB 08/04/22

34

82

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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18 8-4-18

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/04/22

34

counts

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

M-L

08/04/28

34x Counted

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 2:02:15 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SLUG

Job Number: 38678

Part Number: D2587

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

08-04-28

K34

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST34

AS 08/04/28 (34)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/29

Job Completion



mf. 08-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

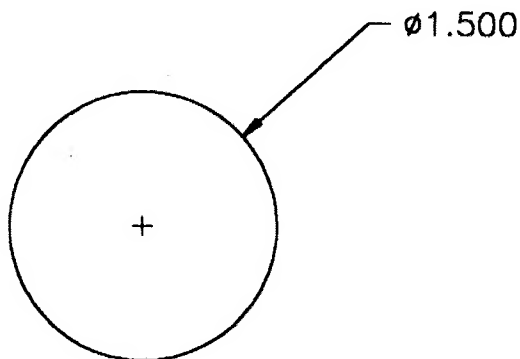
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED	APPROVED	D2587	SHEET 1 OF 1
M. M.	M. M.	TITLE	SCALE
DATE		DOOR SLUG	1:1
96:07:11			
AI		03.09.16 ADD 6061-T6 OPTION	

RELEASED
9607/23 BOW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38678

OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 
MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE